Work Order ID 109162

B109162

\*109162\*

Page 1

November-12-13 3:18:54 PM Item ID: D2932-1 Accept \*N900040100\* Setup Start Revision ID: Stop Item Name: 206 Saddle Left Side Start Date: 11/12/13 Start Qty: 8.00 **Cust Item ID:** Required Date: 11/26/13 Req'd Qty: 8.00 **Customer:** Reference: Run Date: 13-11-12 Tooling: Process Plan: \_\_M\_ \_\_\_\_\_ Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code Number Stamp Qty Qty Draw Nbr **Revision Nbr** D2932 Rev C 0.00 HAAS CNC VERTICAL MACHINING #1 \*100\* 0.00 HAAS 1 Memo HAAS CNC vertical machine #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per 110 0.00 CONVENTIONAL MILLING MACHINE \*110\* Mill Conv 0.00 Memo Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet QC1- Inspect dimensions to dimension sheet 120 -0.00 0.00 Memo Quality Control

DQA:			Date:			WORK ORDER NON-	-00	NEOI	RMANCE / III	DNATE				•	DART
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<b>187</b>						DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS		
Work Orde	er: -					Davisarli	ıl		Skid-tube	Crosstube			Water Jet	$\neg$	Engineering
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		Cracks Crimp/Kir	ok/Binnla	/\M/244	-	Broken/Damage/Defect Burrs	$\vdash$	Hardwa	ire ion Incomplete/U	ngualified		Part Lost/Mi	<u> -</u>		Weld
		Cuffs	ik/ vibbie	, wave	-	Contamination	$\vdash$	1 '	•	•		Part Moved	issuing		
		Crushing			$\vdash$	Countersink	$\vdash$	4	tions Incomplete/I gned/off center	Unicical		Positioned V	L Vrong		Wrong Stock Pulled
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		Inspection		Tube		Drawing	$\vdash$	Misrea				J. OMEL FOSS	Juige [		Other
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		Turning S			-	Finish	$\vdash$	1	Calibration						
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Work Order ID 10	91	62
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Powder Coating

Memo

FINISH TIME:

\*109162\*

Page 2 November-12-13 3:18:54 PM Accept \*N900040100\* Item ID: D2932-1 Setup Start **Revision ID:** Stop 206 Saddle Left Side Item Name: 11/12/13 Start Oty: 8.00 **Start Date: Cust Item ID:** Req'd Qty: 8.00 Required Date: 11/26/13 **Customer:** Reference: Start Run **Tooling:** Process Plan: \_\_\_\_ Date: Date: Approvals: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: QC: Tool ID Tool # Plan Reject Reject Sequence ID/ Accept Insp. **Operation** Set Up/ Number Stamp Qty Code Qty Work Center ID Description **Run Hours** QC8- Inspect parts - second check 0.00 130 m/ 13/11/24 \*130\* 0.00 QC Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 140 8 AG1311.27 \*140\* 0.00 HandFinish Memo Hand Finishing 0.00 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 150 8 \$ 13-11-27. \*150\* 0.00 Powdercoat

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	-					Rework	1		Skid-tube	Crosstube			Water Jet	Eng	ineering
Part N	lo.					Scrap			Machining	Small Fab	T	Prod	d. Eng. Coor.	<b>-</b>	Quality
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		Cuffs			_	Contamination		4	tions Incomplete/	Unclear		Part Moved	L	Wron	ng Stock Pulled
		Crushing			<u> </u>	Countersink		4	gned/off center	ļ		Positioned V		<b>-</b>	
		Heat Trea			L	Cut Too Short	$\vdash$	Mislab		l		Power Loss/	Surge	Othe	r
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Work Order ID 10916	W(	Vork	Order	W	1091	62
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Page 3

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		Accept *	<sup>ะ</sup> N9000	4010	<b>n</b> *			
Start Qty: 8.00	*8* *8*		Cust Item ID: Customer:					. 12
	Date:	Tooling: SPC (Y/N):					`` <b>IV</b> I	R1* R2*
Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00  0.00  DAS 27 9-89 13/11/2			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Identify as per dwg & Sto  Memo	ck Location: 5T43	<b>3</b> 子 0.00 0.00			8×	DAS 28 9-89	13-11	-27
QC21- Final Inspection -	Work Order Release	0.00				13/	11/29	3 AS- WF, 2
	Req'd Qty: 8.00  Plan:  Operation Description QC3- Inspect Part Finish  Memo  Identify as per dwg & Sto  Memo	Start Qty: 8.00 *8* Req'd Qty: 8.00 *8*  Plan: Date: Date:  Operation Description QC3- Inspect Part Finish  Memo  Identify as per dwg & Stock Location: 5743  Memo  QC21- Final Inspection - Work Order Release	Start Qty: 8.00	Start Qty: 8.00 *8* Cust Item ID: Req'd Qty: 8.00 *8* Customer:  Plan: Date: Tooling: Date: Date: SPC (Y/N): Date:  Operation	Start Qty: 8.00	Start Qty: 8.00	Start Qty: 8.00	Start Qty: 8.00

DQA:			Date:										TQ AC
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ır.					DISPOSITION			AGAINST	T DE	PARTMENT	PROCESS	
Work Orac	-				_	Rework	ı		Skid-tube Crosstube	•	]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	-					Use-as-is			moforming Finishing	-	4	e/Packaging	Other
NCR I	۱o. <sub>-</sub>		· · · -			Suspected Unapproved			Large Fab Composite	·[	]	Supplier	
Root					Desc	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Supplier	$\vdash \vdash$		ŀ										
Training	Н												
Transport Unapproved	Н												
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Landi	ne G	iear				General							
		Bending				Bend		Folio/	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	tolerance	Set-up
i i	П	Cracks				Broken/Damage/Defect		Hardw	are		Part Incorre	ri	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
ł	П	Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	<del>-</del>
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	ad				
		Marks/Ch	natter			Drill Holes		Off-set	t				
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tul	ре		Fit/Function		Out of	Sequence				

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November-12-13 3:18:59 PM

Work Order ID: 109162

D2932-1

\*109162\* \*D2932-1\*

Parent Item: D2

206 Saddle Left Side

**Start Date:** 11/12/13

Required Date: 11/26/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: B00.06.26New DWG rev, (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	19.0000	1	8			
**D6101-00	ገ3*								**	8	111	3-11-18	

Saddle Billet, 7075

Location	Loc Qty	Loc Code	
MAT042	1		
103592	1		
MAT045	18		
108298	14		***
97563	4		
106829			_8

DQA:			Date:										TRAC
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QA Closed:			Date:		1		_			VV	ork Order up	date only	
Work Orde	er:				•	DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Orac						Rework			Skid-tube Crosstube		]	Water Jet	Engineering
Part N	No.					Scrap		!	Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	-				_	Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR I	۷o.					Suspected Unapproved			Large Fab Composite		]	Supplier	
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Root					Desc	ription of work order update	i	nitial	Action		Sign &		
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
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Material	Щ												
Operator	Щ			ļ									
Offset/Setup	Щ												
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Supplier	Ш												
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	$\vdash$	Bending			_	Bend	$\vdash$	4	Program	$\vdash$	Outside Dim	<del>-</del>	Pressure/Forced
	Ш	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	-	Set-up
	$oxed{oxed}$	Cracks				Broken/Damage/Defect		Hardwa		$\vdash$	Part Incorre		Temperature/Cure
	_	Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	L	<b>-</b> '	ion Incomplete/Unqualified	$\vdash$	Part Lost/M	- I	Weld
		Cuffs			$\vdash$	Contamination	L	4	tions Incomplete/Unclear	$\vdash$	Part Moved	<u>-</u>	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	_	4	gned/off center	$\vdash$	Positioned V	_	٦
	-	Heat Trea			$\vdash$	Cut Too Short	<u> </u>	Mislab		L	Power Loss/	Surge	Other
		Inspectio		Tube	<u> </u>	Drawing		Misrea					
	<u></u>	Marks/Cl				Drill Holes		Off-set					
		Turning S	-			Finish	$\vdash$	-	Calibration				
		Wave/Tw	vist in Tul	oe		Fit/Function	<u>L.</u>	Out of	Sequence				

DART AEROSPACE LTD	Work Order:	109162
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

	•			Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		, (OS	-114	.108	.110		,
В	0.100	0.140		-105	301.	.106	701.		
С	0.100	0.140		-118	.117	,117	·115		
D	0.210	0.230		,226	.227	, 226	-225		
E	1.245	1.255		1.250	1,250	1,250	(.250		
F	1.245	1.255		1.250	1,250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
Н	0.510	0.515		-510	.50	.510	.50		
Ī	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.260	.760	() 60	-260		
L	0.312	0.317		.716	.3(6	.316	-316		
М	0.235	0.240		239	-239	. 238	. 279		
N	0.100	0.140		1.121	.122	.121	.121		
0	0.540	0.560		.545	1545	.547	.545		
P	0.490	0.510		. 499	, 499	.497	, 5 <sup>22</sup>		
Q	3.715	3.725		3.720	3.420	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.260	.265	.260	.258		
T	0.100	0.180		.140	.140	.(40	.(40		
Ü	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1,367	1.367	1.367	1.630		
W	0.316	0.321		.317	.367	.317	317		
Х	1.125	1.145		1. (30	1.127	1.131	1-131		
Υ	1.565	1.585		1.569	1.566	1.570	1.570		
Z	0.178	0.198		.186	.188	.188	1-570		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
АН									
	Acc	ept/Reje	ct						

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Measured by:	Audited by	Cony
Date: 13 69 (\ - )-0	Date:	13/11/24

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA:			Date:			- · · · · · · · · · · · · · · · · · · ·								
						WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only								
QA Closed:			Date:				_			W	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGA	INST DE	PARTMENT/	PROCESS		
Work Orac	•				<del></del> -	Rework	1		Skid-tube Cross	tube		Water Jet	Engineering	
Part N	lo.				1	Scrap	1		Machining Small	<del></del>	Prod	d. Eng. Coor.	Quality	
	•					Use-as-is			~ <del>~~</del>	hing	•	e/Packaging	Other	
NCR N	۱o.					Suspected Unapproved	]		Large Fab Compo			Supplier		
	-		T		_			<u> </u>			I a. a I			
Root		_			Desci	ription of work order update	1	Initial	Action		Sign &		001	
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design	_													
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Equip/Tooling	$\dashv$													
Handling/Pre	$\vdash$													
Material							Ì							
Operator Offset/Setup											:			
Process							İ							
Supplier					i									
Training														
Transport														
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Landi	ng (	Gear				General			-		_			
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre Not Concentric				BOM/Route		Grain		<u> </u>	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are	<u> </u>	Part Incorred	ci	Temperature/Cure	
		Crimp/Kink/Ripple/Wave			L	Burrs		Inspect	ion Incomplete/Unqualified	'  _	Part Lost/Mi	ssing	Weld	
		Cuffs			<u> </u>	Contamination		4	tions Incomplete/Unclear	<u> </u>	Part Moved	L	Wrong Stock Pulled	
	Crushing					Countersink		-	gned/off center	<u> </u>	Positioned V		<b>–</b>	
	Heat Treat				Cut Too Short		Mislab		L.	Power Loss/	Surge	Other		
		Inspectio	n Strip in	Tube		Drawing		Misrea						
		Marks/Ch				Drill Holes		Off-set				·		
	_	Turning S			. L	Finish	<u></u>	-	Calibration			<del> </del>		
1	l	Wave/Tu	ist in Tub	ne .		Fit/Function	1	IOut of	Sequence					

DART AEROSPACE LTD	Work Order:	109162
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

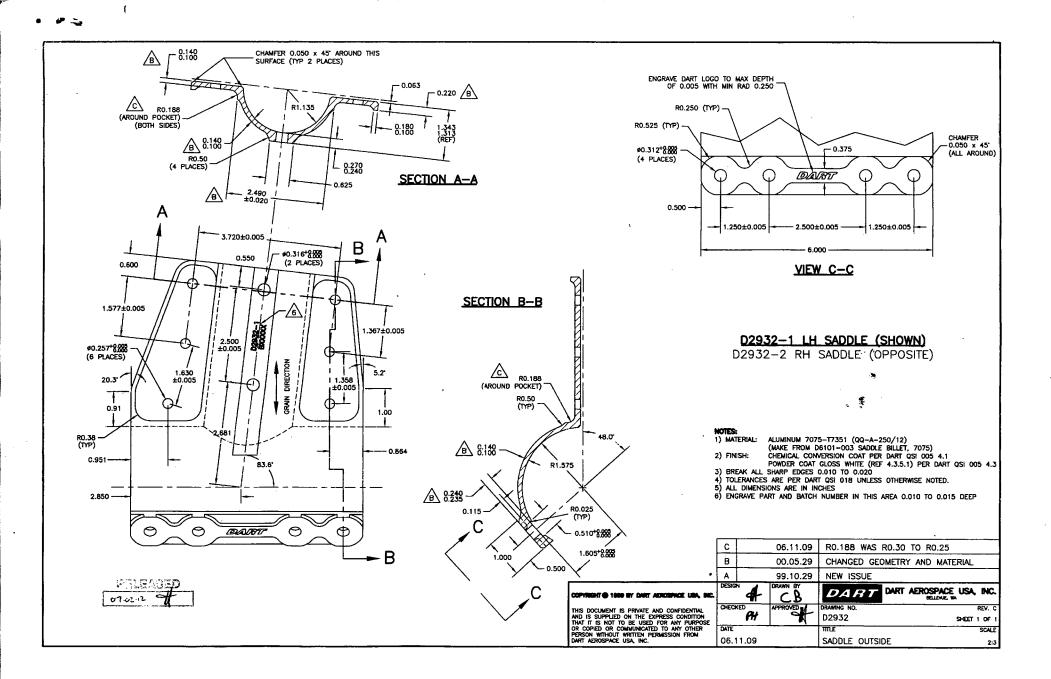
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Re					
Dim	Min	Max	Go/No Go Gauge	54	62	7 &	8 1	Ву	Date
Α	0.100	0.140		.103	.109	.108	· \(D		
В	0.100	0.140		104	.10G	106	106		
С	0.100	0.140		.(16	111%	-116	119		
D	0.210	0.230		.226	.228	. 224	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.290	1.250	1.250		
G	2.495	2.505		2500	2.500	2.500	2.500		
Н	0.510	0.515		1510	,510	,510	.510		
	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		. 260	. 260	. 260	.260		
L	0.312	0.317			-316	.316	.316		
М	0.235	0.240		.239	,239	1.239	238		
N	0.100	0.140		1120	-12-1	().0	-12(		
0	0.540	0.560		547	.446	-546	.547		
Р	0.490	0.510		.495	,494	500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		-260	.259	.258	.260		
T	0.100	0.180	•	.140	.140	140	.140		
U	1.625	1.635		1630	1.630	1.630	1-630		
V	1.362	1.372		1.367	1-367	1.367	1.367		
W	0.316	0.321		317	.317	317	-317		
X	1.125	1.145		1.130	1.131	1.131	1.130		
Υ	1.565	1.585		1.569	1.569	1.570	1.569		
Z	0.178	0.198		-188	188	1.188	.188		
AA				", ", ", "	`				
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Date: 13 - ps - 20	Date:	13/11/24

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM	411

DQA:	Date:												T A A RT	
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